

WHAT IS CLAIMED IS:

- Sub A1* → 1. A method of making a cable tie, said method comprising the steps of:
- (a) forming a strap, said strap having a front end and a tail; and
  - (b) then, insert-molding a front portion onto said front end of said strap, said front portion comprising a head, said head being adapted to cooperate with said strap to form a locked closed loop.
2. The method as claimed in claim 1 wherein said head is shaped to include a channel and a locking tang, said locking tang extending into said channel, and wherein said tail is shaped for insertion through said channel.
3. The method as claimed in claim 2 wherein said strap is shaped to include a plurality of teeth, said teeth lockably engaging said locking tang once inserted therepast.
4. The method as claimed in claim 1 wherein said strap forming step comprises forming a length of continuously molded strap material and then cutting said continuously molded strap material to a desired length.
- Sub A2* → 5. The method as claimed in claim 4 wherein said continuously molding step comprises using rotary extrusion molding.
6. The method as claimed in claim 5 wherein said cutting step comprises punch-cutting said continuously molded strap material.
7. The method as claimed in claim 1 wherein each of said strap and said front portion is made of plastic and wherein said strap forming step and said insert-molding step are performed using identical grades of the same plastic.

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8. The method as claimed in claim 1 wherein each of said strap and said front portion is made of plastic and wherein said strap forming step and said insert-molding step are performed using different plastics.

9. The method as claimed in claim 1 wherein each of said strap and said front portion is made of plastic and wherein said strap forming step and said insert-molding step are performed using different grades of the same plastic.

10. The method as claimed in claim 1 wherein said strap forming step comprises forming a mechanical adhesion promoting element proximate to the front end of said strap.

11. The method as claimed in claim 10 wherein said mechanical adhesion promoting element forming step comprises forming a hole proximate to the front end of said strap.

12. A method of making a cable tie, said method comprising the steps of:

(a) continuously-molding a length of strap material using a rotary extrusion process, said length of strap material having a front end, a rear end and a bottom surface, said bottom surface being shaped to include along its entire length a plurality of laterally-extending teeth;

(b) then, cutting said length of strap material to yield a strap of desired length, said individual strap having a front end and a tail; and

(b) then, insert-molding a front portion around said front end of said strap, said front portion comprising a head, said head being shaped to include a channel through which said tail may be inserted and also being shaped to include a locking tang for lockably engaging said teeth once inserted therepast to form a locked closed loop.

13. The method as claimed in claim 12 further comprising, prior to said insert-molding step, the step of forming a transverse hole in said strap proximate to said front end of said strap and wherein said insert-molding step comprises molding through said transverse hole.

14. A cable tie comprising:

(a) a strap, said strap being an elongated flexible member having a front end and a tail; and

(b) a front portion insert-molded onto said front end of said strap, said front portion comprising a head, said head being adapted to cooperate with said strap to form a locked closed loop.

15. The cable tie as claimed in claim 14 wherein said strap has a bottom surface shaped to include along its entire length a plurality of laterally-extending teeth.

16. The cable tie as claimed in claim 15 wherein said head is shaped to include a channel through which said tail of said strap is insertable and a locking tang lockably engageable with said laterally-extending teeth once inserted therepast.

17. The cable tie as claimed in claim 16 wherein said front portion further comprises a neck extending rearwardly from said head, said front end of said strap being disposed within said neck.

18. The cable tie as claimed in claim 17 wherein said strap is shaped to include a mechanical adhesion promoting element disposed within said neck.

19. The cable tie as claimed in claim 18 wherein said mechanical adhesion promoting element is a transverse hole.

20. The cable tie as claimed in claim 14 wherein said strap and said front portion are made of the same material.

21. The cable tie as claimed in claim 20 wherein said strap and said front portion are made of identical grades of nylon.

22. The cable tie as claimed in claim 14 wherein said strap and said front portion are made of different materials.

23. The cable tie as claimed in claim 22 wherein said strap and said front portion are made of different grades of nylon.

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